



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G11831-3G-05

Job Sheet 198085



Part No: RBW6305G11831-3G-05

Job Qty: 1 pcs *169 ml*

Part Name: Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/20/19

Type: SOLD

Description:

Note: DWG RBW6305G11831-3G Rev. 2 IPP Rev. A 18.09.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off	
					Setup Hrs	Run Hrs		Workcenter / Supplier Lead Time
120	Conventional Lathe - 1	1 pcs	9/20/19	9/20/19	0.00	0.13	Conventional Lathe - 1	21 19-93
							Conventional Lathe - 2	
130	QC 2	1 pcs	9/20/19	9/20/19	0.00	0.00	QC 2 - 1	21
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

Plex 7/22/19 11:37 AM Dart.lajeunesse.marie

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140 QC 8	1 pcs	9/20/19	0.00 0.00	QC 8 - 12	BAS 14 9-89
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Outsource - 13 - Zinc Plating	1 pcs	9/20/19	0.00 0.00	GROO2	2019-09-12
160 Packaging 2-1 - Recelve - B4B	1 pcs	9/20/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	SEP 20 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	

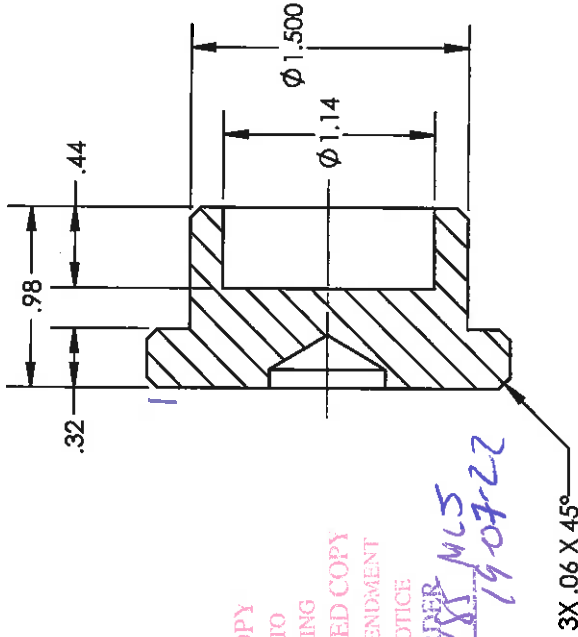
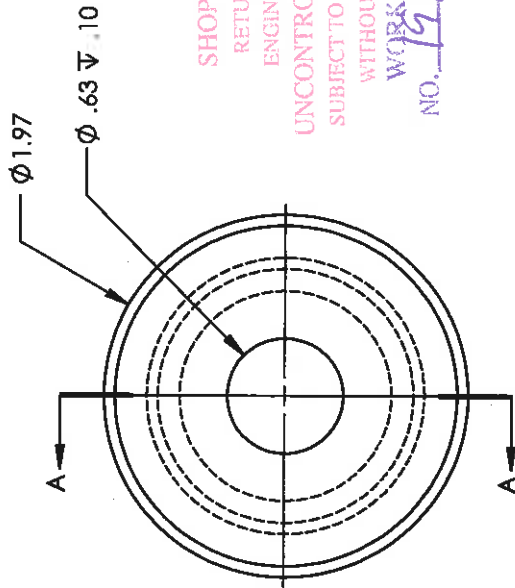
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	1 pcs	9/20/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	SFP 2 4 2019
					QC 6 - 81	9-89
180	Packaging 3-2 - Stock - B4B	1 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	1 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
Part Op 120 - (Manufacture as per dwg)1-Machine as per DWG. 2-Deburr Descriptions: 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 150 - (Outside Processing - Zinc Plating)-Issue P/O to GROUPE ALTECH: P/O 44486 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required 160 - (Receive & Inspect for Damage & Mat'l Certs)Receive 170 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location:)Identify and Stock 190 - QC21- Final Inspection - Work Order Release)						

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.000	AISI 4140 Quenched & Tempered Steel Round Bar 2.000" Dia.	.0816 ft (.0816 ea)	120-Conventional Lathe - 1	S169097 = .593
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Conventional Lathe - 1	MT-4140QT-R2.000	0	10	0
Part Specifications				
Specifications could not be found.				

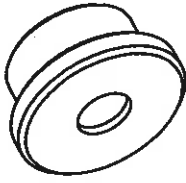
Plex 7/22/19 11:37 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REV	ECR	DESCRIPTION	REVISIONS	DATE	INITIAL	APPROVED
A		CHD -.05 FINISH SPEC PER R.W.		5/4/2011	RJC	



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 198088 M15
190722



TITLE		PULLER, MGB INPUT GIMBAL REMOVAL	
DWG NO.		RBW 6305G11831-3G-05	
MATERIAL		4140 Q&T/142 Q&T	
DRAWN BY		PERRITT	
APPROVED		D Med	
UNLESS OTHERWISE SPECIFIED		DIMENSIONS ARE IN INCHES	
XXX ± .005		FRACTIONS ± 1/8	
XX ± .01		ANGLES ± .5°	
X ± .1		FINISH	
1. BREAK ALL SHARP EDGES .015 X 45°		SPEC QQ-P-416F, TYPE II, CLASS II	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE		1:1	
DATE		5/11/2010	
SHEET		4 OF 6	

Ø .05

CAP

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																												
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																												
Description Work Order Deviation																																		
Disposition																																		
Completed By _____																																		
Lead hand / Supervisor _____																																		
QC / QA Coordinator _____																																		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>					Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																															
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																															
Crushing	BOM/Route	Grain Direction	Drawing																															
Cracks	Broken/Damage/Defect	Weld	Finish																															
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																															
Marks/Chatter	Drill Holes	Out of Sequence	Misread																															
Mislabeled	Fit/Function	Off-set/Set-up																																
Other/Details: _____																																		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044486



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044486

PO Date: 9/12/19

Due Date: 9/20/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

RECEIVED
2019-09-13

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197838	RBE1X56-131-405	Socket Wrench -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color: Clear -Material type: 4140 -Certificate of Conformity is required	Firmed - X3		9/20/19	3 pcs	0 pcs	3 pcs	\$10.00/pcs	\$30.00
							SEP 18 2019				
							SZ12117				
2	198085	RBW6305G11831-3G-05	Cap (Outside Processing -Zinc Plating)-Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color: yellow -Material type: 4140 -Certificate of Conformity is required	Firmed - X6		9/20/19	6 pcs	0 pcs	6 pcs	\$11.25/pcs	\$67.50
							SEP 20 2019				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044486



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198237	RBE105-31702W19-5	Shaft -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color: Clear -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/20/19	6 pcs	0 pcs	6 pcs	\$10.00/pcs	\$60.00
				X6			SEP 18 2019				DP
							5208505				
4	200280	RBW6305G11731-3G-03	Pusher Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/20/19	2 pcs	0 pcs	2 pcs	\$11.25/pcs	\$22.50
				X2			SEP 20 2019				DP
Grand Total:											\$180.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/13/19 3:50 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022389-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022389 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Sep-2019		Jigar Patel		POHB044486				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBW6305G11831-3G-05 Rev.	RBW6305G11831-3G-05 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	6	6	0	0	0
4	RBW6305G11731-3G-03 Rev.	RBW6305G11731-3G-03 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	2	2	0	0	0

RECEIVED
 SEP 20 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.